CEWELD AA NiCro 600B

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic flux-cored nickel base welding wire for gas shielded arc welding.

APPLICATIONS

AA NICRO 600B is developed for welding and cladding nickel-based alloys such as alloy 600 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels or to stainless steels. AA NICRO 600B can also be used on difficult to weld steels !

PROPERTIES

Latest generation basic slag quality guarantees optimum metallurgical quality and attractive welder appeal. The weld deposit meets the NiCrFe-3 requirements. Better bead aspect and shape compare to solid wires with better arc stability and improved wetting properties with less spatters. Excellent results are also achieved without protective gas.

CLASSIFICATION

EN ISO	12153-A: T Ni 6082 (NiCr15Fe6Mn) R M21 3
W.Nr.	2.4648
F-nr	43
FM	6

SUITABLE FOR

E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni6082
2.4630, 2.4631, 2.4669, 2.4816, 2.4817, 2.4851, 2.4867, 2.4870, 2.4951 ...(1.4816, 1.4864, 1.4876, 1.4583, 1.4886, 1.5637, 1.5662, 1.5680, 1.6900, 1.6901, 1.6903, 1.6906)
NiCr20Ti, NiCr21TiAl, NiCr15Fe7TiAl , NiCr15Fe , LC-NiCr15Fe, NiCr23Fe, NiCr60 15, NiCr80 20, NiCr 10 , NiCr20Ti 1.5637 12 Ni 14, X8Ni9 , 12Ni19 , X12CrNI18 9, GX8CrNi18 10 , X10CrNiTi18 10 , X5CrNi18 10
UNS Nr: K81340 - N06600 - N06601 - N08800 - N08810
ASTM B163, B166, B167 und B168
Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Nb	Fe	S
0.01	0.3	5	16.5	Rem.	1.7	6	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -196°C	Hardness
As Welded	390	610	45	90	HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

M21